



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D4269-7 Job Sheet 189635



Part No: D4269-7

Job Qty: 5 pcs

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/28/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A IPP Rev:A 11.04.04 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

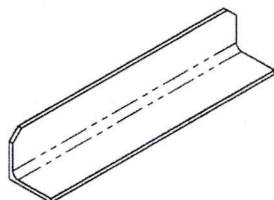
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS 58 Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	5 pcs	2/28/19	0.00	3.73	Small Fab - 1			MAR 05 2019	
						Small Fab - 2				
						Small Fab - 3				
						Small Fab - 4				
						Small Fab - 5				
						Small Fab - 6				
						Small Fab - 7				
110	QC 6	5 pcs	2/28/19	0.00	0.00	QC 6 - 38		MAR 11 2019	DAS 68 9-89	
						QC 6 - 42				
						QC 6 - 9				
						QC 6 - 68				
						QC 6 - 61				
120	Handfinish - 1-1 Chemical-B4B	5 pcs	2/28/19	0.00	0.50	Handfinish - 1 - 1 - B4B		D.R 19/03/12		
						Handfinish - 1 - 2 - B4B				
						Handfinish - 1 - 3 - B4B				
						Handfinish - 1 - 4 - B4B				
						Handfinish - 1 - 5 - B4B				
						Handfinish - 1 - 6 - B4B				
						Handfinish - 1 - 7 - B4B				
						Handfinish - 1 - 8 - B4B				
						Handfinish - 1 - 9 - B4B				
						Handfinish - 1 - 10 - B4B				
						Handfinish - 1 - 11 - B4B				
						Handfinish - 1 - 12 - B4B				
						Handfinish - 1 - 13 - B4B				
						Handfinish - 1 - 14 - B4B				

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 3	5 pcs	2/28/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
140 Packaging 3-1 - Stock - B4B	5 pcs	2/28/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

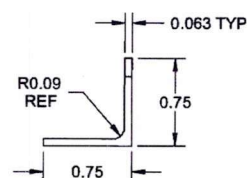
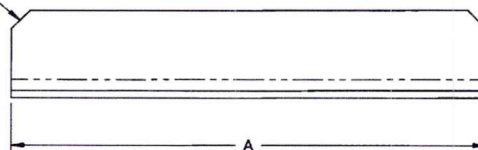
MAR 12 2019

DAS
40
9-89

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5x237 8 MAR 12 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150	QC 21 - SA	5 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
Part Op 100 - (Small Fab) Descriptions: 110 - QC6- All purchased or subcontracted products) 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - QC3- Inspect Part Finish) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)					
DAS 70 9-89					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3A.750X.750X.063W	Angle2024T3511 .750 x .750 x .063w	9.1800 ft (1.836 ea)	100-Small Fab - 1	S156889	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	M2024T3A.750X.750X.063W	9	12	0	
Part Specifications					
Specifications could not be found.					



0.16 x 45°
CHAMFER
2 PL



D4269-X

(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

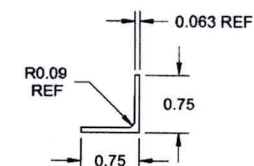
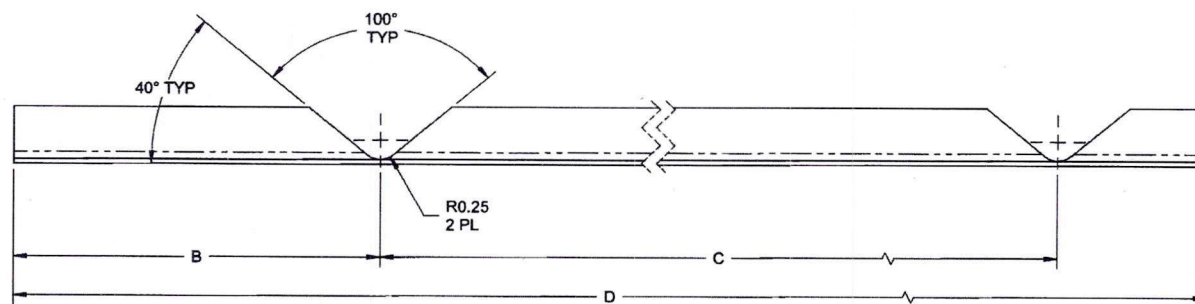
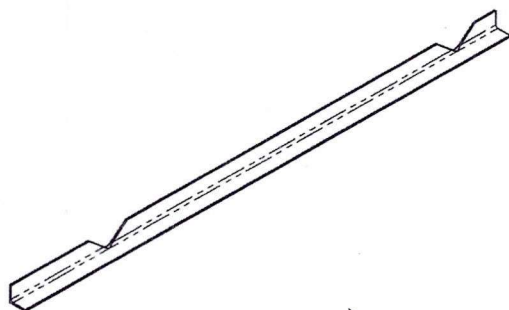
PART NUMBER	DESCRIPTION	EA20469-Y	A	WEIGHT
D4269-1	ANGLE	EA20469-33	4.03	0.04
D4269-3	ANGLE	EA20469-30	4.63	0.04

RELEASED
2011-04-06
WNT

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4269	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4269-Z
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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RELEASED
2011-04-06

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4269	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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www.dartaerospace.com

Container No: S158980



Part: D4269-7

Job No: 189635

Serial No/Batch: S158980

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dr 03/05/19